

4

Date: Friday, 12/21/2007 7:28:23 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL ASSEMBLY
 Job Number : 36527
 Estimate Number : 11005
 P.O. Number :
 This Issue : 12/21/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D412704041
 First Issue : 1/1 Type : SMALL /MED FAB Drawing Number : D412-704-041 REV A
 Previous Run : 35841 Project Number : N/A
 Material :
 Due Date : 1/20/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : AS 07.12.21
 Comment : Est Rev:B 05.01.28 Removed hardware on Step 2; Added
 Figures 1-3 KJ/RF
 Est Rev:C 06.03.08 Re-format EC
 Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20
 JLM
 Est Rev:E 07.05.02 Reformat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3204041 Pedal Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3204-041	Pedal Assembly	34237x3

B37775 x1

New Batch

AS 08/04/04 (x4)

2.0 D32051 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3205-1	Bracket	34238x1

B 35854 (3)

AS 08/04/04 (x4)

3.0 D32053 Back Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3205-3	GHW Bracket	B35209

B35209

AS 08/04/04 (x4)

4.0 D32061 Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
			36535

36535

AS 08/04/04 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36527

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3206-1 Pedal arm

5.0

D3209041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	D3209-.041	Bracket

batch

30832

old Batch *

AS 08/04/04 (x)

6.0

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN3-10A	Bolt

batch

M17566

AS 08/04/04 (x)

7.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN315-4R	Nut

batch

M17566

AS 08/04/04 (x)

8.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN4-10A	Bolt

batch

M105442

AS 08/04/04 (x)

9.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description
2	AN4-12A	Bolt

batch

M105443

AS 08/04/04 (x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch

1 AN4-13A Bolt

106993

AS 08/04/04 (x4)

11.0

AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part number Description batch

5 AN960JD10 Washer

M106552

AS 08/04/04 (x4)

12.0

AN960JD416

Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part number Description batch

11 AN960JD416 Washer

M106780

AS 08/04/04 (x4)

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part number Description batch

3 AN960JD416L Washer

M107008

AS 08/04/04 (x4)

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch

1 MS21042L3 Nut

M106883

AS 08/04/04 (x4)

15.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part number Description batch

5 MS21042L4 Nut

M106825

AS 08/04/04 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	M14604

AS 08/04/04 (x4)

17.0

MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	M100290

AS 08/04/04 (x4)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

CB 08/04/24 (4)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/24 (x4)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	M104885

AS 08/04/24 (x4)

W/O:		WORK ORDER CHANGES					
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Machine Or Operation:

Description :

22.0

AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part number Description batch

2 AN3-6A

Bolt

batch M100662

AS 08/04/24 (x4)

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch:

M106883

AS 08/04/24 (x4)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/04/25 (x4)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPD 37100

AS 08/04/25 (x4)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28 (x4)

Job Completion



MF 08-04-25

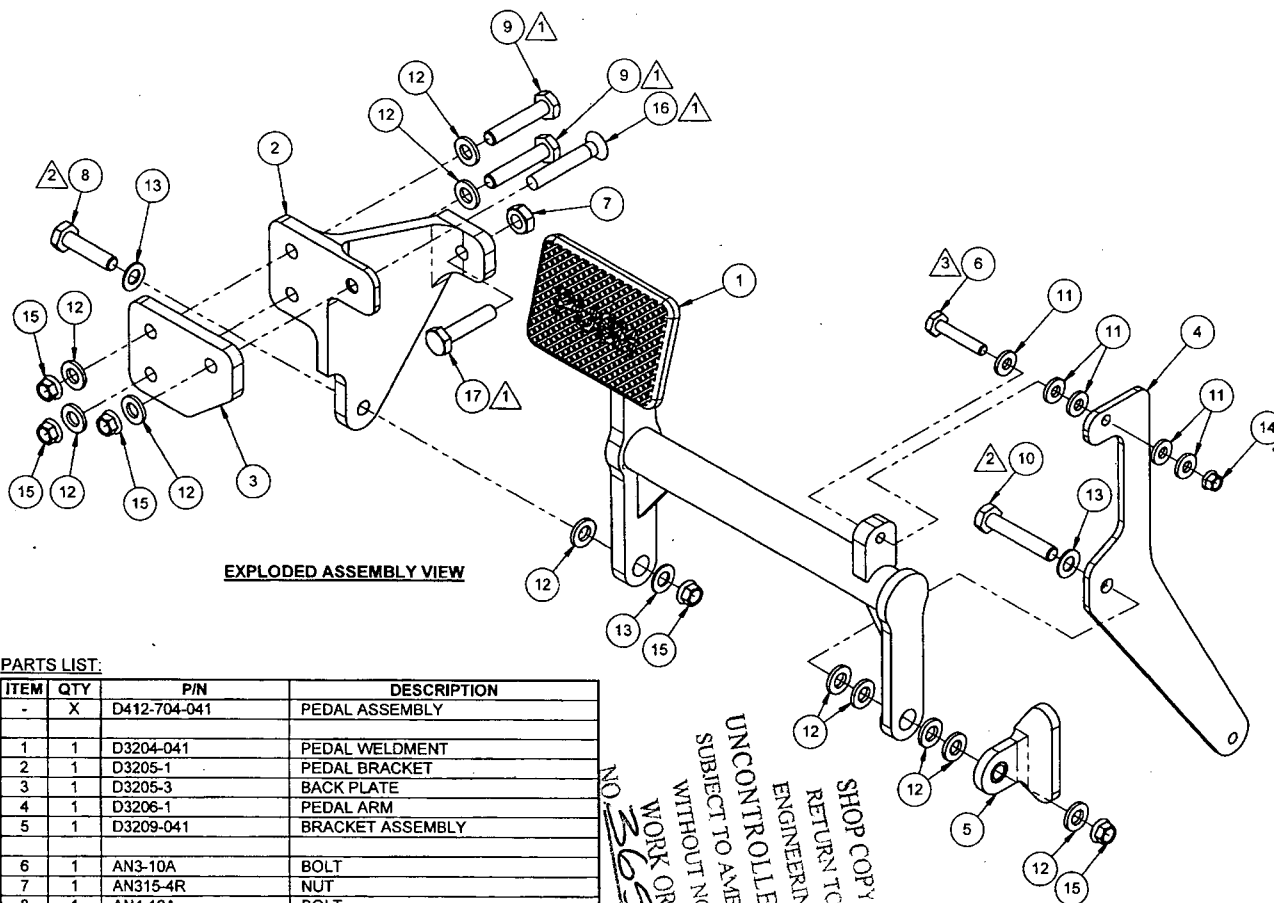
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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EXPLODED ASSEMBLY VIEW

PARTS LIST:

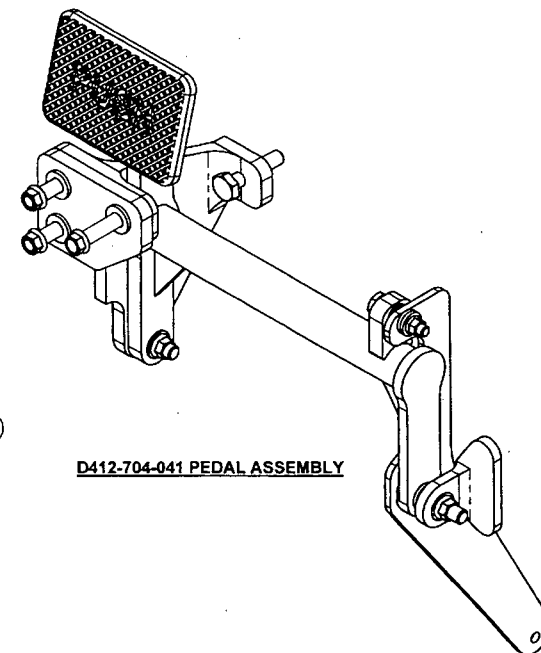
ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NO
36527
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).



D412-704-041 PEDAL ASSEMBLY

RELEASED

07.01.23

A	REV	07.01.23	NEW ISSUE	DESCRIPTION
DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	C.E.	APPROVED	[Signature]	DRAWING NO. D412-704-041
DATE	07.01.23	TITLE	PEDAL ASSEMBLY	REV. A SHEET 1 OF 1 SCALE 1:2

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